Work Order ID 117868

May-05-14 11:46:34 AM

117868

Item ID: D2565-111 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Strut

Start Date: 5/12/14 **Start Qty:** 6.00 *6* **Cust Item ID:**

Required Date: 5/12/14 **Req'd Qty:** 6.00 *6* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** MLJ **Date:** 14-05-06 **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	**Revision Nbr**								
D2565	Rev E								
100	Punch ends and deburr as per dwg	0.00			DAS 30 9-89	6			14/06/10
100	NC BRAKE								
Brake NC	**Memo**	0.00							
Brake NC	Punch as per Dwg D2565 using DT 8313								
110		0.00							DAS 36 9-89
110	Small Fab					6x			14/08/06
Small Fab	**Memo**	0.00							
Small Fab	Deburr								
120	QC5- Inspect part completeness to step on W/O	0.00			DAS 38 9-89	6			
120					DAS 9 9-89				
QC	**Memo**	0.00			14/08/06				
Quality Control									

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
☐ Centre Not Concentric
☐ Cracks
☐ Crimp/Kink/Ripple/Wave
☐ Cuffs
☐ Crushing
☐ Heat Treat
☐ Inspection Strip in Tube
☐ Marks/Chatter
☐ Turning Sequence
☐ Wave/Twist in Tube

General

☐ Bend
☐ BOM/Route
☐ Broken/Damage/Defect
☐ Burrs
☐ Contamination
☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function

☐ Folio/Program
☐ Grain
☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence

☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge

☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled

☐ Other

Item ID: D2565-111 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Strut

Start Date: 5/12/14 **Start Qty:** 6.00 *6*
Required Date: 5/12/14 **Req'd Qty:** 6.00 *6*
Reference:

Cust Item ID:
Customer:

Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00				6			CR 14-08-13
130									
Powdercoat	**Memo**	0.00							
Powder Coating	START TIME: 12:00 OVEN TEMPERATURE: 400 FINISH TIME: 12:00								
140	QC3- Inspect Part Finish	0.00				6 & 22			14/08/13.
140									
QC	**Memo**	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: ST354	0.00				6X			AUG 14 2014
150									
Packaging	**Memo**	0.00							
Packaging									

DAS 28 9-89

DQA: _____ Date: _____

DART AEROSPACE

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
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FAULT CATEGORY

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- ☐ Crushing
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- ☐ Marks/Chatter
- ☐ Turning Sequence
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General

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- ☐ Broken/Damage/Defect
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- ☐ Cut Too Short
- ☐ Drawing
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- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other

Item ID: D2565-111 **Accept** *N9000040100* **Setup Start** *NS1*
Revision ID: **Stop** *NS2*
Item Name: Strut

Start Date: 5/12/14 **Start Qty:** 6.00 *6* **Cust Item ID:**
Required Date: 5/12/14 **Req'd Qty:** 6.00 *6* **Customer:**
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Run Start *NR1*
Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	**Memo**	0.00							
Quality Control									

MCJ 14-08-15

MCJ 1408-15

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
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Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
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FAULT CATEGORY

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☐ Drawing
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☐ Hardware
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☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
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☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Picklist Print

May-05-14 11:46:34 AM

Work Order ID: 117868 *117868*

Parent Item: D2565-111 *D2565-111*

Parent Item Name: Strut

Start Date: 5/12/14 **Required Date:** 5/12/14

Start Qty: 6.00 **Required Qty:** 6.00

Comments: IPP: E01.06.04Added Powder Coat, Removed Polish, and Added Inspection Levels 3 & 21 EC
IPP: E06.05.03 Change level 2/8 to QC5 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.750W.049		Purchased	No			100	f	123.7261	1.1375	8		DAS 30 9-89	
M304TR0.750W.049									**				
304 RD Tube .750 x .049W													

Location	Loc Qty	Loc Code	
MAT017	123.7261		
122312	4.04		
124768	49.27		
M126183	25.4399		2
M128084	44.9762		
			8

M129188

14/06/10

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

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Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

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Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

DART AEROSPACE LTD

Description: Strut | Work Order: 117868

Inspection Drawing: D2565 | Rev: E | Part Number: D2565-111

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
13.65	+/-.020	13.67	✓		T	SS-11
12.85	+/-.030	12.87	✓		T	SA-11

Measured by:	Checked By:	QC inspector:	Engineering Approval (*if necessary*)
DAS 30 9-89	DAS 30 9-89		
Date 14/06/10	Date 14/06/10	Date 14/08/15	Date